



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2708-01-15

Job Sheet 197519



Part No: RBE350A94-2708-01-15

Job Qty: 4 pcs

Part Name: Rod Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Small Fab - 1	4 pcs	9/2/19		0.00	0.80	Small Fab - 1	
							Small Fab - 2	MLL
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	4 pcs	9/2/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
121	Outsource - 12 - Black Oxide	4 pcs	9/2/19				GRO002-VC	10
122	Packaging 2-1 - Receive - B4B	4 pcs	9/2/19		0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	



Container No: S199245

Part: RBE350A94-2708-01-15

Job No: 197519

Serial No/Batch: S199245

Revision: G

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 07/18/19

DAS
40
9-80

JUL 22 2019

18 2019-07-24

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				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
123	QC 6	4 pcs	9/2/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
130	Packaging 3-1 - Stock - B4B	4 pcs	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B

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				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

AUG 01 2019

Part Op 110 - (Small Fab) -Press fit -05 into -03 as per DWG. Sheet 3

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

121 - Issue P/O: 44113 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

122 - (Receive & Inspect for Damage & Mat'l Certs) Receive

123 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A593	Dowel Pin	4 Ea (1 ea)	110-Small Fab - 1	5050893
RBE350A94-2708-01-03	Rod	4 pcs (1 ea)	110-Small Fab - 1	5192875

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	98381A593	4	6	0
	RBE350A94-2708-01-03	4	9	0

Part Specifications

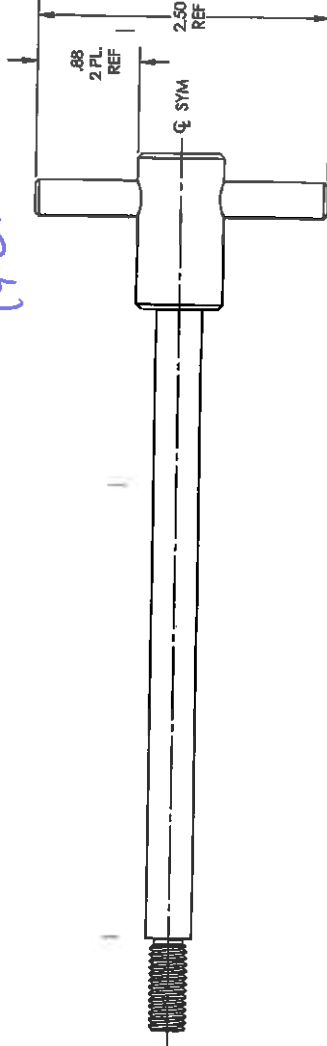
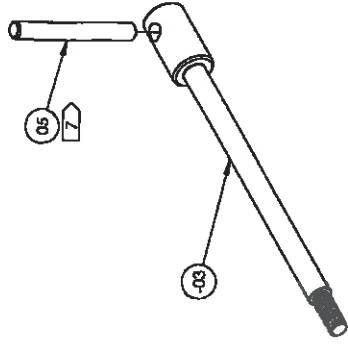
Specifications could not be found.

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ITEM #	QTY	PART #	TITLE
-03	1	RBE350A94-2708-01-03	ROD
05	1	McMaster#88381A583	DOWEL PIN 5/16" X 2-1/2" LG.

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
G	ASSY ADDED	17-804	01/02/2018	VM	ML

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197519 MJS
190710



RBE350A94-2708-01-15 ROD ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE (NEUTRALIZE AFTER BLACK OXIDE TREATMENT)
 - 4) SPEC: MIL-C13924, CLASS 1; MIL-C-16173 GRADE 4
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) PRESS DOWEL INTO ROD

DART AEROSPACE		Hamilton, Ontario, Canada	
TITLE ROD ASSY			
PART NO.	RBE350A94-2708-01-15	REV	G
TOTAL NO. OF SHEETS: 1 SHEET NO.: 1 DRAWN BY: VM 01/02/2018 CHECKED BY: VM 01/02/2018 APPROVED BY: ML 01/02/2018 SCALE: 1:1 SHEET 1 OF 1			
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By		MRB (QS1042)			
Lead hand / Supervisor		QC / QA Coordinator			



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044113



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044113

PO Date: 7/24/19

Due Date: 8/1/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196531	RB T103388- 101-103	Alignment Tail Rotor Driveshaft Bolt -Issue P/O; -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	24 pcs	0 pcs	24 pcs	\$3.7357/pcs	\$89.66
2	194687-A	RBA8100- 80902-201	Wrench -Issue P/O; -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/1/19	4 pcs	0 pcs	4 pcs	\$4.9357/pcs	\$19.74



Dart Aerospace Ltd.
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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197521	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/1/19	20 pcs	0 pcs	20 pcs	\$3.2857/pcs	\$65.71
				X20			JUL 30 2019			DP	
4	194332	RBT18666-5	Slotted Plate -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/1/19	8 pcs	0 pcs	8 pcs	\$21.25/pcs	\$170.00
				X3			JUL 30 2019			DP	
5	196723	RB6795969-1	Shaft -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	4 pcs	0 pcs	4 pcs	\$6.2857/pcs	\$25.14
				X4			JUL 30 2019			DP	
6	197519	RBE350A94-2708-01-15	Rod Assembly -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	4 pcs	0 pcs	4 pcs	\$6.6357/pcs	\$26.54
				X4			JUL 30 2019			DP	
Grand Total:										\$396.80	



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PURCHASE ORDER

POHB044113



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 8:11 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021040-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

021040 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
30-Jul-2019	Jigar Patel		POHB044113					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT103388-101-103 Rev.	RBT103388-101-103 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	24	24	0	0	0
2	RBA8100-80902-201 Rev.	RBA8100-80902-201 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
3	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	20	20	0	0	0
4	RBT18666-5 Rev.	RBT18666-5 ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
5	RB6795969-1 Rev.	RB6795969-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
6	RBE350A94-2708-01-15 Rev.	RBE350A94-2708-01-15 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0

RECEIVED

JUL 30 2019

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance

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Livré à / Ship to

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 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
30-Jul-2019		Jigar Patel		POHB044113					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.